



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D3220-042
Job Sheet 163050



Part No: D3220-042

Job Qty: 4 ea

Part Name: Doubler Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 12/1/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV B IPP Rev:A New Issue 05-11-06 JLM IPP: B 06.11.15 waterjet EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/30/17	0.00	0.00	Start Up Waterjet		SC 8/2/14
100	Waterjet	4 pcs		11/30/17	0.06	0.32	Waterjet1		SC 18/02/14
110	QC	4 pcs		11/30/17	0.00	0.00	QC2		SC 18/02/14
120	QC	4 pcs		11/30/17	0.00	0.00	QC8		38
130	Small Fab	4 pcs		11/30/17	0.00	0.29	Small Fab		9-88
140	QC	4 pcs		11/30/17	0.00	0.00	QC5		9-88
150	HandFinish	4 pcs		11/30/17	0.00	0.39	HandFinish1		BEB 18-02-21
160	QC	4 pcs		11/30/17	0.00	0.00	QC3		
170	Small Fab	4 pcs		12/1/17	0.00	0.29	Small Fab		DAS
180	QC	4 pcs		12/1/17	0.00	0.00	QC5		38
190	Packaging	4 pcs		12/1/17	0.00	0.00	Packaging3		9-88
200	QC21-SA	4 Ea		12/1/17	0.00	0.00	QC21	STH85	DAS FEB 22 2018

Part Op 100 - 1-Cut D3220-2 as per Dwg D3220

Descriptions: 130 - 1-Deburr 2-C'sink D3220-2 as per Dwg D3220

170 - Assemble D3220-042 doubler as per Dwg D3220

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	2.7704 sf (.6926 ea)	90-Start up Operation	
MS20426AD3-3	Rivet	32 Ea (8 ea)	170-Small Fab	5018535
MS21059L4	Nutplate	16 Ea (4 ea)	170-Small Fab	5016885

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.050	3	130	0
170-Small Fab	MS20426AD3-3	32-48	6,185	0
	MS21059L4	16-24	39	0

Part Specifications

Specifications could not be found.



AEROSPACE

Container No: S042344

Part: D3220-042

Serial No/Batch: S042344

Revision: D3220

Inspector:

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Date: 02/14/18 12:58 PM

DART AEROSPACE LTD		Work Order:	163050
Description: Doubler		Part Number:	D3220-2
Inspection Dwg: D3220	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.50	+/-0.030	5.502	1		VPC-02	
14.25	+/-0.030	14.25	1		Tape	
R0.50	+/-0.030	R0.50	1			
7.00	+/-0.030	7.00	1			
7.000	+/-0.005	7.000	1			
1.50	+/-0.030	1.496	1			
1.000	+/-0.005	1.001	1			
0.500	+/-0.005	0.501	1			
1.000	+/-0.005	1.002	1			
Ø0.316	+0.006/-0.001	Ø0.316	1			
Ø0.098	+0.004/-0.001	Ø0.100	1			
0.050 thick	+/-0.005	0.050	1			
Grain Direction	N/A	OK	1			

Measured by: SC	Audited by: DAS 38	Preliminary Approval:
Date: 18/02/14	Date: FEB 14 2018	Date:

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue P/O D3220-042	KJ/JLM	
B	13.03.07	Dwg Rev updated	KJ	